

# Work Order ID 107485

September-26-13 8:21:54 AM

**\*107485\***

Page 1

Item ID: D4417-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Assembly  
 Start Date: 9/26/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 10/10/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 13-09-26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4417	B								
100	Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 to 106"AS PER DWG								
	2-DRILL HOLES USING DT9765								
	3-CUT ENDS AT 45 DEG AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89  
13926

② 13-09-26 ①  
2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				2	0	13-9-26	De
140 <b>*140*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				2	0	13-10-02	DAS 19 9-26
150 <b>*150*</b> Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>123928</u> Large Fab Memo 1-SWAGE TUBES AS PER DWG 2-Weld cap per dwg D4417 3-grind flush	0.00 0.00				2	0	13-10-02	13-10-02

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 Item Name: Step Assembly  
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 Required Date: 10/10/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				2			
			DAS 27 9-89 1310.7						
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				2			
			DAS 27 9-89 1310.7						
180 <b>*180*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo 1-Touch up alodine	0.00  0.00							

START TIME: 8:20  
 OVEN TEMPERATURE: 320°F  
 FINISH TIME: 8:50

2 XPM 13/10/08

M126125

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 Item Name: Step Assembly  
 Start Date: 9/26/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 10/10/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 B HandFinishing Memo	11/26506 0.00 0.00				2	6	BL B-10-8.	
200 <b>*200*</b> QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	4	13/10/08	
210 <b>*210*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>FP</u> Memo	0.00 0.00						MF 13-10-08	

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Item ID: D4417-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Assembly

Start Date: 9/26/13 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 10/10/13 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

*[Signature]* / *RM* 13/10/08.*MF*  
*13-10-08*

# Picklist Print

September-26-13 8:21:58 AM

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Work Order ID: 107485

**\*107485\***

Parent Item: D4417-041

**\*D4417-041\***

Parent Item Name: Step Assembly

Start Date: 9/26/13

Required Date: 10/10/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP  
REV:B 11.08.17 PER REV.B. DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			100	Each	228.7700	1	2			
------------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

**\*D2622-120C\***

Step Extrusion

\*\*

13-09-26 PD

Location	Loc Qty	Loc Code
HALL	125	
105575	125	
WA003	103.77	
101765	89.8	
81507	4	
89750	7.87	
98024	2.1	

D2734

Manufactured No

150

Each

256.0000

2

4

**\*D2734\***

Step End Plate

\*\*

13-10-02

Location	Loc Qty	Loc Code
WA003	256	
102618	84	
105712	150	
80682	6	
84563	10	
91761	6	

D4425-1

Manufactured No

150

Each

31.0000

2

4

**\*D4425-1\***

Step Spacer

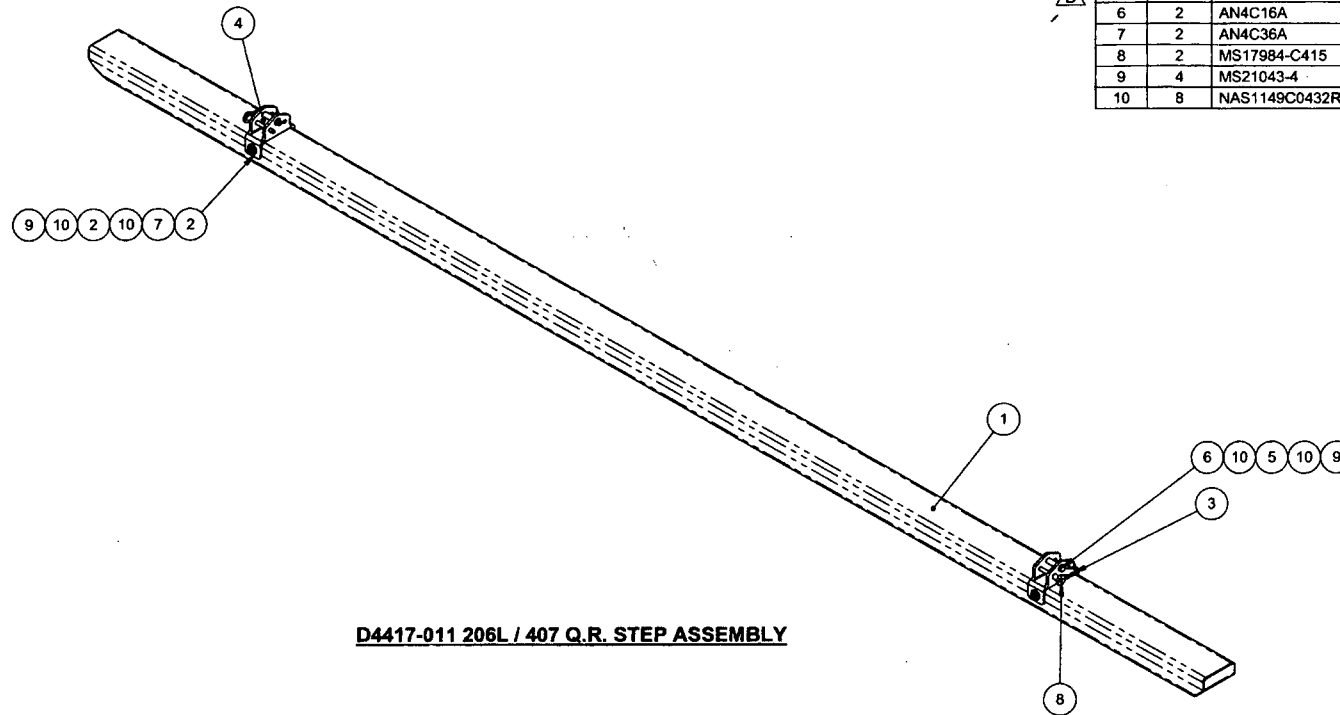
\*\*

13-10-02

Location	Loc Qty	Loc Code
WA003	31	
85917	25	
85965	6	

4

ITEM	QTY	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER



**D4417-011 206L / 407 Q.R. STEP ASSEMBLY**

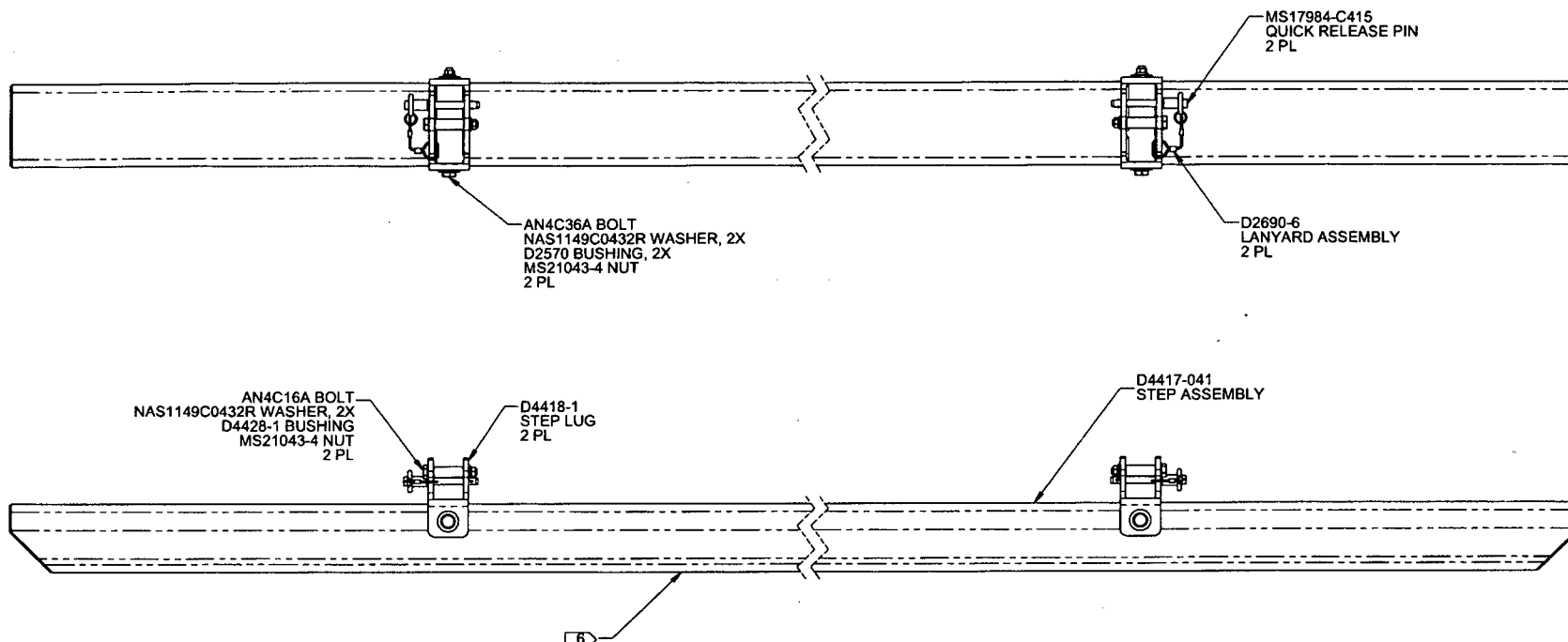
UNCLAS  
SECRET

107485 MJS  
1309-26

**RELEASED**  
2011-08-02

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -5.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.28		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4417</b> TITLE <b>206L / 407 Q.R. STEP ASSEMBLY</b> REV. B SHEET 1 OF 4 SCALE NTS <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

107485



**D4417-011 206L / 407 Q.R. STEP ASSEMBLY**

**RELEASED**  
2011-08-02  
*MD*

**NOTES:**

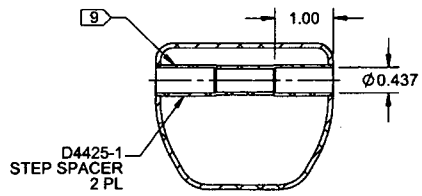
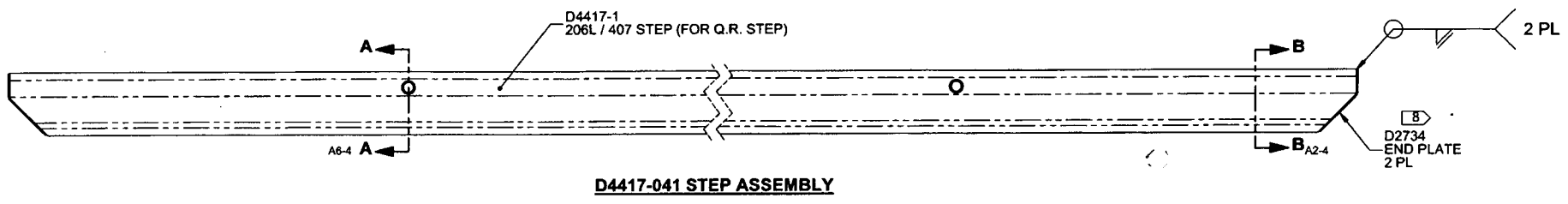
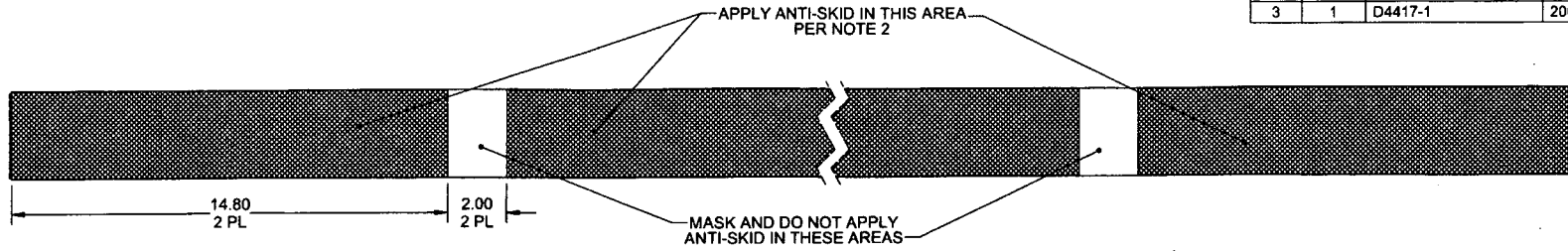
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4417-011" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 8.75 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4417</b>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>206L / 407 Q.R. STEP ASSEMBLY</b>	NTS
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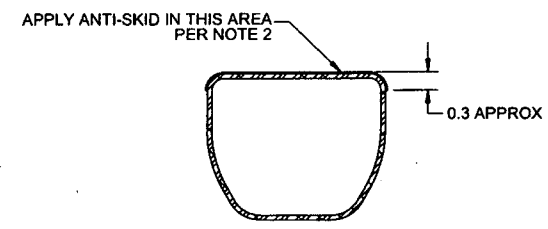


107485

ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



**SECTION A-A** C7-4  
SCALE 2X



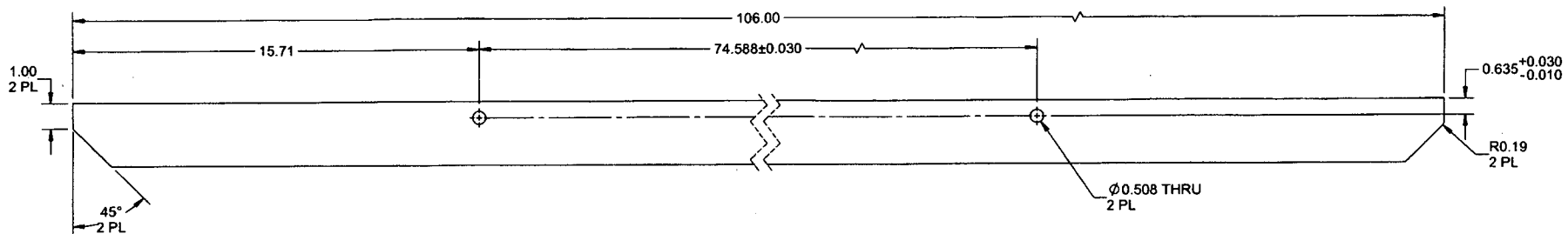
**SECTION B-B** C2-4  
SCALE 2X

**RELEASED**  
2011-08-02  
MD

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 8.00 lbs
  - 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
  - 9) SWAGE TO  $\phi 0.437$  X 1.00 DEEP PER QSI 002

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	2	DRAWING NO.	REV. B
MFG. APPR.	2	<b>D4417</b>	SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
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10748J



**D4417-1 206L / 407 STEP (FOR Q.R. STEP)**

**RELEASED**  
2011-08-02

- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 7.77 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4417</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>206L / 407 Q.R. STEP ASSEMBLY</b>	NTS
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